

Date: Monday, 5/15/2006 1:06:03 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 27130		
Estimate Number	: 10206		
P.O. Number	: N/A	Part Number	: D2989041
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 26721A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/19/2006 Qty: 1 Um: Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est Rev: Removed D2989-043 05-11-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: B25896

PD

06-05-16

2.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets B26204

PD

06-05-16

3.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing B25823

PD

06-05-16

4.0	D2506	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate B26631

PD

06-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total: 15.0000 sf(s)

Pick:

Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal

M100122
M100072

PD

06-05-17

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total: 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M100783

PD

06-05-16

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

PD

06-05-18

8.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06/05/18

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

a.m 06-05-19 ①

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M19640

Wing Walk: M100652

FC

06 05 19 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	App. Mfg / Design Mgr	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/19

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Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

u 06-05-19

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

u 06/05/19

Job Completion



u 06-05-19

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____